										· .
Work Orde July-23-12 10:48		584		*875	841*					Page 1
Revision ID:	D3838-041 Rib Assembly	(Basket Lid, LH)		Accept	*N900	04010 0)* s	etup Start	171	S1* S2*
	8/06/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				
Approvals:	Process Pla	in: MLJ	Date: \2 03	Tooling: SPC (Y/N):		ate:	R	tun Start	· · · V	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr				7			*	
D3838	Rev	' A								
100		Large Fab,		0.00			×3	(3-0	7-22 1

Large Fab

Memo

0.00

1- cut D3838-1 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batcl 1/1/22 35 7

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838 A/R ER316 S.S. Rod Batch: M 122357

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

NCR: Ye	s / No				1	WORK ORDER NON-C	O۱	IFORM	MANCE / UPD	ATE		•		
										. ,,,	QA Clo	sed:	Date:	
Vork Order:	:					DISPOSITION				AGAINST D	EPARTN	IENT/	PROCESS	
Part No						Rework Scrap Use-as-is Work Order Update		! Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Red		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Desc	riptio	on of work order update	li	nitial	Acti	on	Sign	&		
Cause	Date	Step	Qty		or l	Non-conformance	Ch	ief Eng	Descri	ption	Da	te	Verification	QC Inspector
perator laterial etup ther rocess upplier raining napproved										,				
		_1				F#	UL	T CATE	GORY					
Landing	Gear			_		General								
	Bending				Ве	end		Grain			Ovaliz	ed		Pressure/Forced
	Centre No	ot Concer	ntric to	o/s	B	OM/Route		Hardwa	re		Over/l	Jnder	tolerance	Temperature/Cure
	Cracks				Bı	roken/Damaged		Inspecti	on Incomplete		Part In	corre	ct	Weld
	Crushed/	Crimped			Bu	urrs .		Instruct	ions Incomplete/U	nclear	Part Lo	ost/Mi	ssing	Wrong Stock Pulled
	Cuffs			. [\Box cc	ontamination		Mainte	nance		Part N	loved		,
	Heat Trea	at			$\neg c$	ountersink		Mislabe	led	Γ	Positio	ned V	Vrong	
	Inspectio	n Strip in	Tube		Cı	ut Too Short		Misread	i	Ī	Power	Loss/	Surge	Other
	Ripples in	n Bend		Γ	D	rill Holes		Offset		_				
	Torque W	Vaves in E	Extrusio	, [rawing		Out of (Calibration			·		
	Turning S	equence		Γ	Fii	nish		Out of S	Sequence		 			
	Wave/Tw	ist in Tuk	эe		Fo	olio		Outside	Dimensions		************			

DQA:

Date:

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Work Orde July-23-12 10:4		584		*87.5	584*			Page 2
Item ID: Revision ID:	D3838-041			Accept	*N90004010)()* Seti	ıp Start	*NS1*
Item Name:	Rib Assembly	(Basket Lid, LH)					Stop	*NS2*
Start Date:	8/06/12	Start Qty: 1.00	*1*		Cust Item ID:			
Required Date:	8/17/12	Req'd Qty: 1.00	*1*		Customer:			
Reference:						D	Start	
Approvals:	Process Pla	an:	Date:	Tooling:	Date:	Rur —		*NR1*
·	QC:				Date:	_	Stop	*NR2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID Tool # Plan	-		Reject Insp. Number Stamp
130		QC9- Inspect visual per	QSI004- Fusion Welds	0.00		2AQ\		
130 QC Quality Control		Memo		0.00			SSI	13 07 23 3
140 * 4 4 0 *		QC5- Inspect part compl	leteness to step on W/O	0.00			v 00 0	DAS (DAS
*14 0 *		Memo		0.00			1800°	
Quality Control						S	/	• •
				•				
150		Identify as per dwg & St		0.00			. /	
150		Booket o		0.00		. —————————————————————————————————————		413.07.23

0.00

150 Packaging

Packaging

Memo

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	VFORM	MANCE / UPI	DATE		·		•	
												QA Closed:	Da	ite:	
Work Ord	er:	i				DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part I	No.	:				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
						,	J		· Ш	• •					
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance	ı	Initial nief Eng		ion ription		Sign & Date	Verificatio	ın	QC Inspector
Doc/Data	Γ	- Julie	эсер	Qty	`	or non comormance	-	ner Eng	Deser	iption.	+	Dute	Vermedile		QC IIISPECTOI
Equip/Tooling	 				•										
Operator	\vdash														
Material		1											:		
Setup		ļ									ļ				
Other					÷										
Process		'													
Supplier	\Box														
Training		' '					ĺ			-	١				
Unapproved		!													
	1		.		L	F	AUL	T CATE	GORY		_				
Landi	ng (Gear				General									
		Bending				Bend		Grain			٦	Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re .		٦	Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete	Γ	٦	Part Incorre	ct		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions incomplete/l	Unclear	٦	Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		٦	Part Moved			•
		Heat Trea	t			Countersink		Mislabe	eled			Positioned V	Vrong		
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		٦	Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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Work Ord July-23-12 10:		584	·	*875		Pag					
Item ID: Revision ID: Item Name:	D3838-041 Rib Assembly	(Basket Lid, LH)		Accept	*N900	<u>040</u>	100)* s	Setup Sta	1421	
Start Date: Required Date Reference:	8/06/12 :: 8/17/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	ID:					
Approvals:	Process Pla	n:	Date:	Tooling: _ SPC (Y/N):		ate:			Run Sta Sto	"NR1"	
Sequence ID/ Work Center I 160 *160* QC Quality Control	Operation Description		- Work Order Release	Set Up/ Run Hours 0.00			Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp	

NCR:	Yes /	No	

										•	DQA:	Date:	
NCR: Y	es	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPD/	ATE	QA Closed:	Date:	
Vork Orde	r					DISPOSITION				AGAINST DE			
Part N	 o					Rework Scrap Use-as-is Work Order Update	,	Therm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty	Des	tion of work order update r Non-conformance	1	nitial ief Eng	Actio Descrip		Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining													
······	•					 F/	AUL	T CATE	SORY	·			
Landir	ng Go	ear			_	General		_					·
		Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in	t n Strip in Bend aves in E	Tube xtrusion		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/Un nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing .	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
i i	I١	Turning So	eauence		`	Finish	1	Out of 9	equence	1			

Outside Dimensions

Wave/Twist in Tube

Folio

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Page 1

Work Order ID:

87584

Parent Item:

D3838-041

Parent Item Name:

Rib Assembly (Basket Lid, LH)

Start Date: 8/06/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date S Issued	tatus
D3759-1	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Manufactured	No				Each	277.0000		1			
Bushing B 100	32.7 (X	3)1	÷	Location WA 792 8346 865:	64	Loc Oty 276 1 75 200	<u>Lo</u>	oc Code	×3		13-	07-do	L MA
				WA005 664	89	1							`,
M304TS0.750W.065 304 SQ Tube .75x.75x.065	5W	Purchased	No			100	f	2,099.4321	1.0317	1.086			720041
		7		Location		Loc Qty	La	oc Code			1		

M 10 55/3	-	×3.1257
~9317		22.7) [10.12

Location	Loc Qty	Loc Code	
MAT	978.9473		
112398	0		
122051	978.9473		_
MAT017	1079.484837		
120267	26.9468670		
120633	52.53797		, · · · · · · ·
122468	1000		
MAT018	41		
7636	. 41		·

-125' 13-07-22 may

1

														1
												DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	O	VFORM	MANCE / UPI	DATE		•	· · · · · · · · · · · · · · · · · · ·	
		•										QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAIN	ST DE	PARTMENT	/PROCESS	
Work Ord	C1.					Rework	1		Skid-tube	Crosstul	ae 🗀		Water Jet	Engineering
Part !	No.					Scrap	1		Machining	Small F		Pro	d. Eng. Coor.	Quality
				•		Use-as-is			noforming	Finishi	_		re/Packaging	Other
NCR	No.					Work Order Update		·	Large Fab	Composi	te		Supplier	
Root						ption of work order update	1	Initial		tion		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	QC Inspector
Doc/Data	_													
Equip/Tooling														
Operator	\vdash													,
Material Setup														·
Other	-													
Process	\vdash													
Supplier														
Training			ļ.											
Unapproved							1							
						F	AUL	T CATE	GORY					
Landi	ing (Gear				General		=				-	·	_
		Bending				Bend	<u>_</u>	Grain				Ovalized		Pressure/Forced
,	<u></u>	Centre No	ot Concer	ntric to	o/s	BOM/Route	<u></u>	Hardwa	re		<u> </u>	Over/Under	}	Temperature/Cure
	<u> </u>	Cracks			<u></u>	Broken/Damaged		1	on Incomplete		L	Part Incorre		Weld
	<u></u>	Crushed/	Crimped.		<u> </u> _	Burrs	_	4	ions Incomplete/	Unclear	\perp	Part Lost/Mi	issing	Wrong Stock Pulled
1	<u> </u>	Cuffs				Contamination	<u></u>	Mainte			<u> </u>	Part Moved		
	\vdash	Heat Trea			<u> </u>	Countersink	<u></u>	Mislabe				Positioned V		7
		Inspectio	•	Tube	<u> </u>	Cut Too Short	\vdash	Misread	d			Power Loss/	Surge	Other .
		Ripples in				Drill Holes		Offset						· · · · · · · · · · · · · · · · · · ·
i		Torque W	/aves in E	xtrusio	n {	Drawing	1	Out of 0	Calibration					

Out of Sequence

Outside Dimensions

Turning Sequence

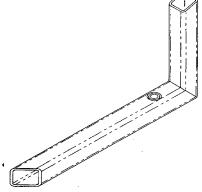
Wave/Twist in Tube

Finish

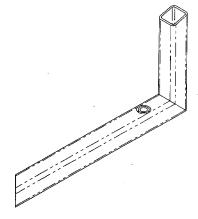
Folio

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QTY QTY -041 -042 ITEM P/N DESCRIPTION D3838-041 RIB ASSY (BASKET LID, LH) 2 X D3838-042 RIB ASSY (BASKET LID, RH) D3759-1 BUSHING D3838-1 RIB 1 D3838-2 RIB RIB 1 D3838-3



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER MLJ NO. 87584 MLJ 12/07/24

Α	NEW IS	SUE	ME	3 08.10.08
REV.			DESCRIPTION BY	DATE
DESIGN DRAWN		b	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECK MFG. A		MSS	DRAWING NO. D3838	REV. A
APPRO			RIB ASSY (BASKET LID)	SCALE NTS
DATE	08.1	0.08	COPYRIGHT © 2008 BY DART AEROSP THIS DOCUMENT IS PRIVATE NO CONFIDENTIAL AND IS SUPPLIED ON THE E NOT TO SE USED FOR MAY PLAPOSE OR COPIED OR COMMUNICATED TO AN INSTITUTE PROSECON FROM DART AFROPMOS.	PRESS CONDITION THAT IT IS NOTHER PERSONWITHOUT

NOTES:
1) MATÉRIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs

D

